

# STAVIS SEAFOODS, INC.

## AMMONIA REFRIGERATION MANAGEMENT PROGRAM STANDARD OPERATING PROCEDURES — HIGH STAGE RECIPROCATING COMPRESSOR OPERATION

<b>Manual shutdown procedures (normal shutdown and shutdown for maintenance operations)</b>	1. For a normal, short duration shutdown, go to the control or starter panel, or the M&M panel, and simply turn the compressor start/stop switch to the off position.	During normal operations, the compressor is automatically started and stopped, and will automatically load and unload based on suction pressure.
	2. For a long term or maintenance shutdown, good practice would be to decrease the load, close the suction service valve RC1-V-1 / RC2-V-1 / RC3-V-1, allow the compressor to pumpdown, go to the control station and turn the compressor start/stop switch to the off position	Follow steps 2 — 12 only if the shutdown is for compressor maintenance.
	3. Follow the lockout/tag-out procedures described in the lockout / tag-out manual and, if available, the specific lockout/tagout procedure that accompanies this SOP to lockout the appropriate disconnects and valves as necessary.	
	4. Close and tag the*isolation valve RC1-V-2 / RC2-V-2 / RC3-V-3 located in the compressor discharge line.	
	5. Close and tag the isolation valve RC1-V-5 / RC2-V-5 / RC3-V-6 located in the line that connects the oil separator to the oil float.	
	6. Close and tag the isolation valve RC1-V-9 / RC2-V-9 / RC3-V-14 located on the compressor, left of the suction service valve.	
	7. Carefully and slowly, loosen the union on the steel tube oil return line that is connected to valve RC1-V-5 / RC2-V-5 / RC3-V11 in order to bleed the ammonia vapor to atmosphere.	
	8. After the oil return line has completely purged, remove the line and adapter from valve RC1-V-2 / RC2-V-2 / RC3-V-3	